

(f3)

Work Order ID 56919

March 12, 2010 1:40:35 PM



Page 2

Item ID: D3705-11

Accept



Setup Start



Revision ID:

Stop



Item Name: MAIN PANEL

Start Date: 3/15/10 Start Qty: 2.00



Cust Item ID:

Required Date: 3/15/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr if necessary.

W/A

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

pk 10-3-15

(3)

Work Order ID 56919

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Page 3

Item ID: D3705-11

Accept



Setup Start



Revision ID:

Stop



Item Name: MAIN PANEL

Start Date: 3/15/10 Start Qty: 2.00



Cust Item ID:

Required Date: 3/15/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M105642

Memo

0.00

START TIME: 11:00

3:00 FINISH TIME:

OVEN TEMPERATURE:

11:30

Bl 10-3-15

(3)

(3)

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

8:00/15

Memo

0.00

(x3)

180



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

Per 3/15 (3)

Work Order ID 56919

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Page 4

Item ID: D3705-11

Accept



Setup Start



Revision ID:

Stop



Item Name: MAIN PANEL

Start Date: 3/15/10

Start Qty: 2.00



Cust Item ID:

Required Date: 3/15/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/15

MUF

10-3-15

Picklist Print

March 12, 2010 1:40:34 PM

Page 1

Work Order ID: 56919

Parent Item: D3705-11

Parent Item Name: MAIN PANEL

Comments: IPP Rev:A 09-01-09 rev.c as per dwg DD verified by:EC

Start Date: 3/15/10

Required Date: 3/15/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

286.3841

0.7000

1.1



B 10-3-15

6061-T6 .063 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110551

113608

286.3841211

18.1841211

268.2

113608

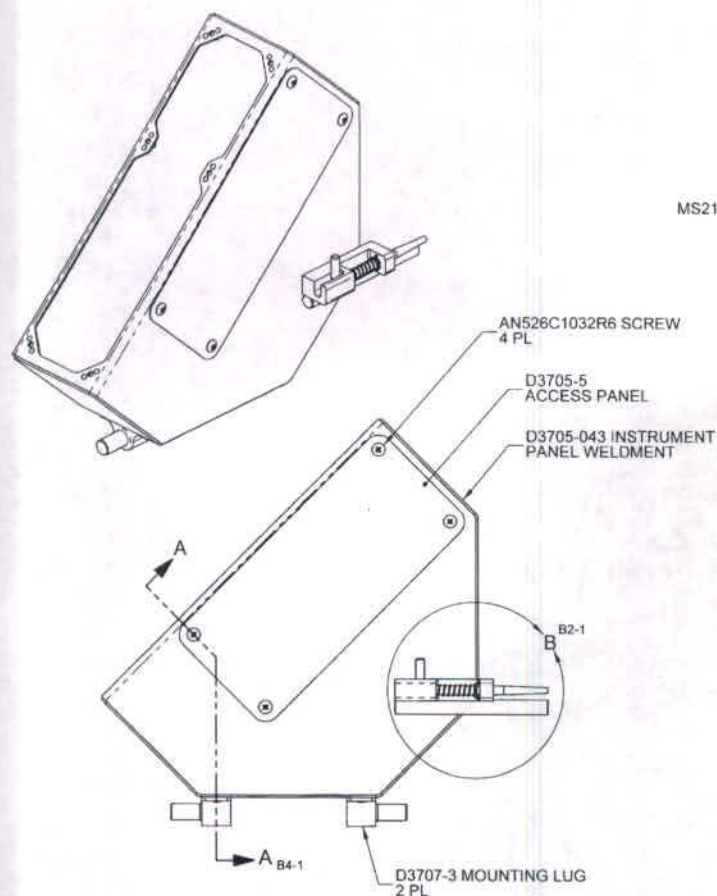
DART AEROSPACE LTD		Work Order: 56919
Description: MAIN PANEL		Part Number: D3705-11
Inspection Dwg: D3705-11 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.150	+ .010 - .001	3.153	X			
Ø .201	+ .005 - .001	.204	X			
.700	± .010	.702	X			
.573	± .010	.574	X			
1.125	± .010	1.123	X			
2.175	± .010	2.176	X			
.295	± .010	.296	X			
.368	± .010	.370	X			
1.445	± .010	1.446	X			
1.795	± .010					
2.520	± .010	2.523	X			
3.222	± .010	3.222	X			
3.295	± .010	3.296	X			
3.59	± .030	3.598	X			
7.150	± .010	7.150	X			
8.625	± .010	8.627	X			
11.050	± .010	11.053	X			
12.927	± .010	12.927	X			
13.50	± .030	13.50	X			
1063	± .010	1059	X			

Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 10-3-15	Date: 10/03/15	Date: N/A
Rev A	Date	Change
		New Issue
Revised by: KJ/JLM	Approved	

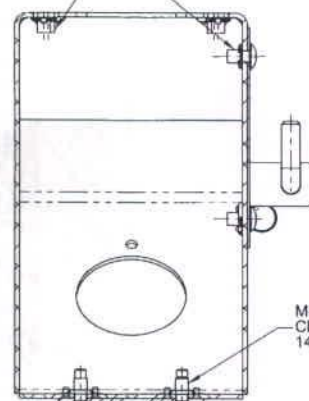


D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.97 lbs

MS21075L3 NUTPLATE
REF



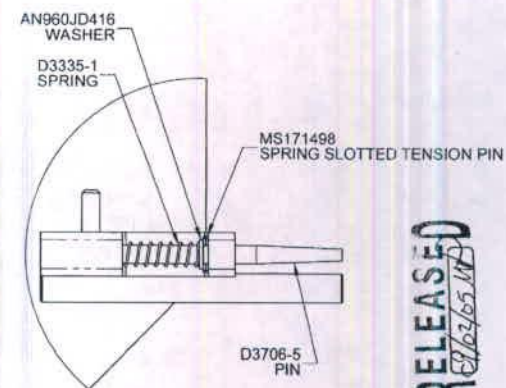
SECTION A-A
SCALE 2X

MS21075L3 NUTPLATE, 1X
CR1122-3-02.5 RIVET, 2X
14 PL

MS24693-C272 SCREW
4 PL

D3707-3 MOUNTING LUG
REF

ITEM	QTY 041	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASS'Y
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET



DETAIL B
SCALE 2X

C	ADDED D3705-71-94-11 (SHEET 6); REMOVED MS35589-156 GROMMET, 9.31 AND 12.86 WERE 9.38 AND 12.81 (ZN B6-3); 9.1.90 WAS 1.50 (ZN D5-4); ADDED Ø0.204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35489-156; QTY 14 MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-09 & AN960JD10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	AS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.20		

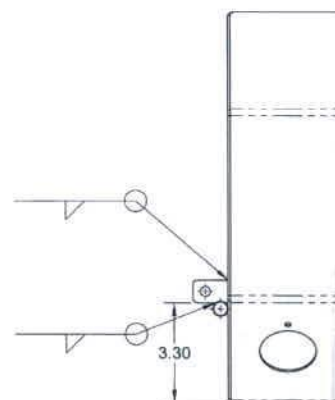
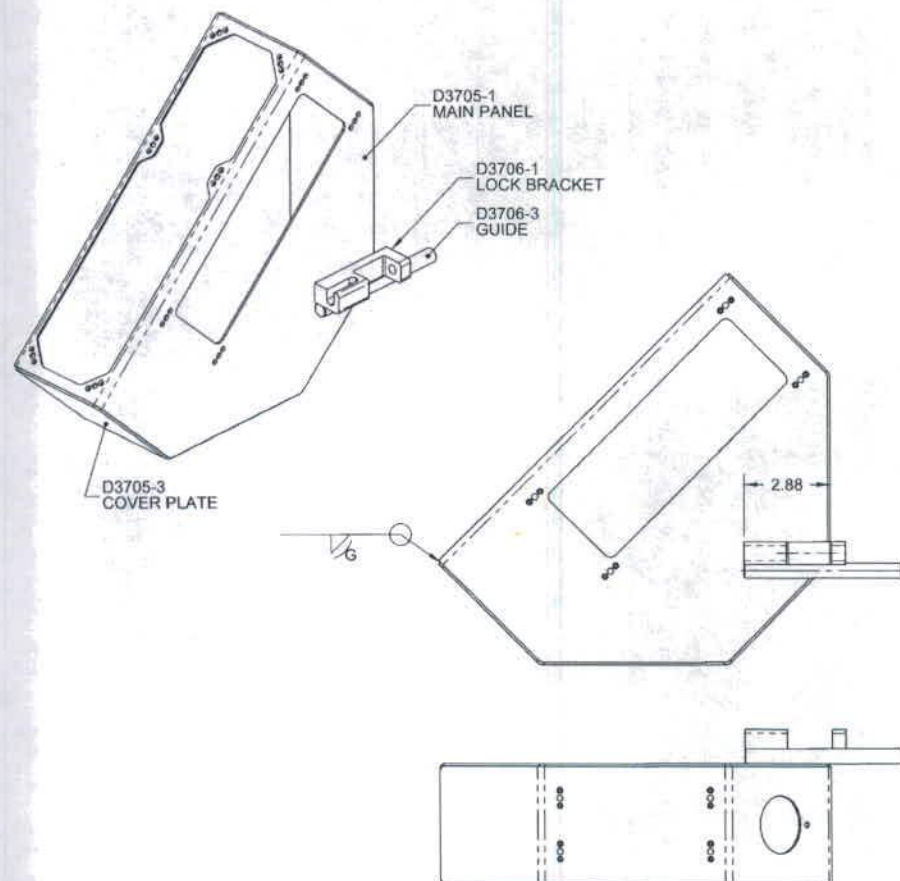
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3705
SHEET 1 OF 5
TITLE
INSTRUMENT PANEL ASS'Y
SCALE
NTS

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RELEASED
8/16/2015

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

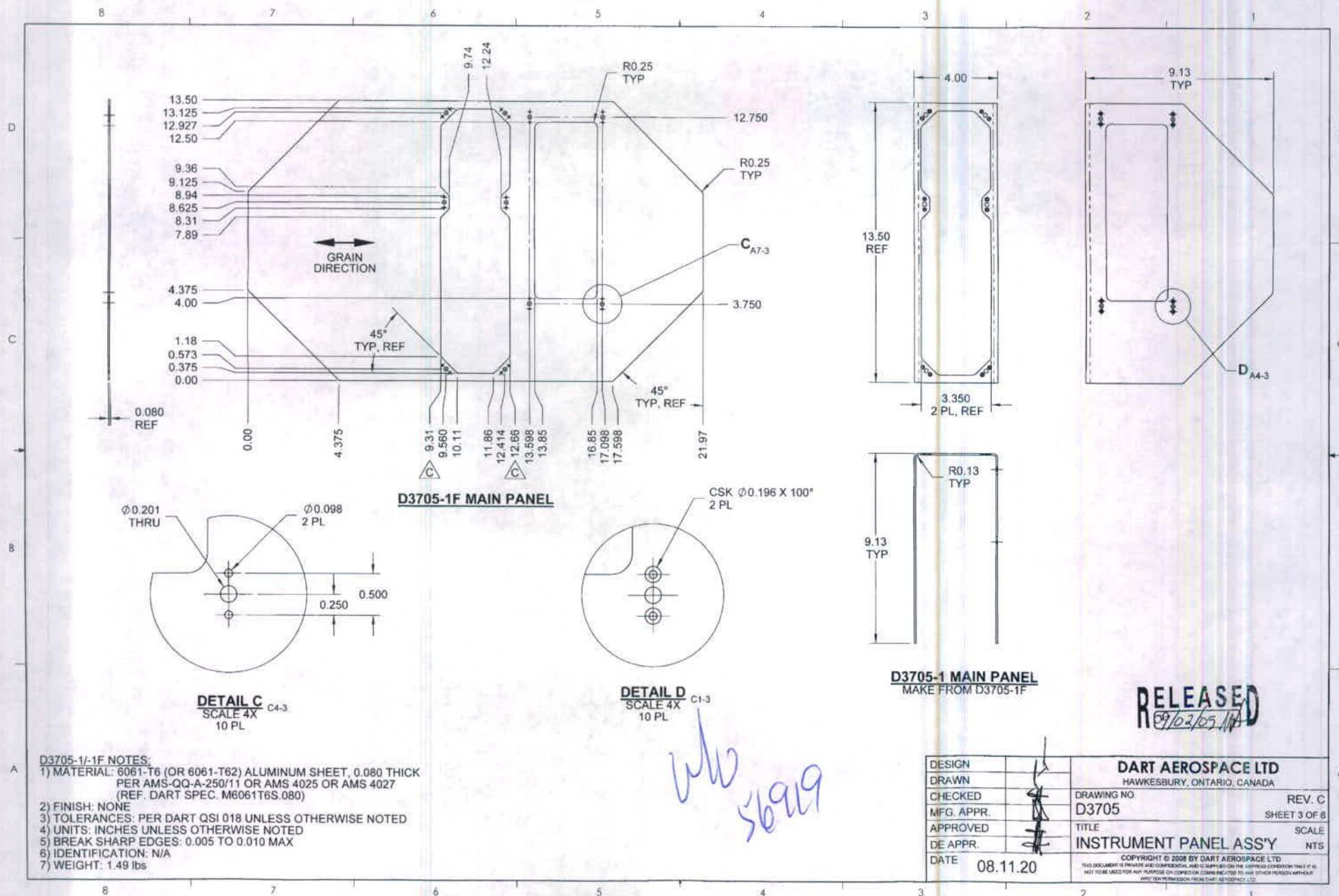
D3705-043 NOTES:

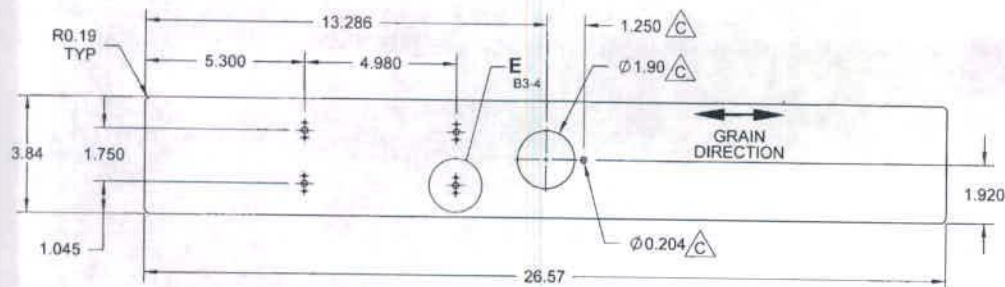
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

WLB 56919

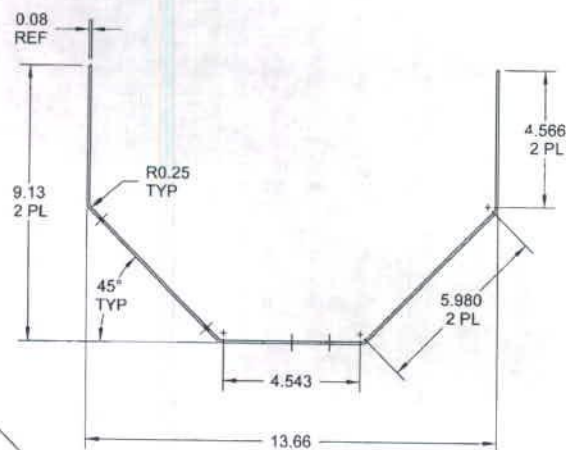
RELEASED
08/12/05 MJB

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MFG. APPR.		D3705	SHEET 2 OF 6
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DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
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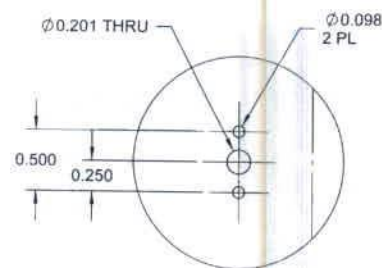
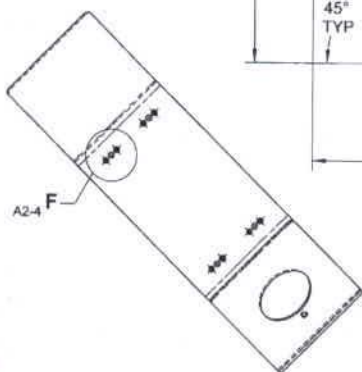




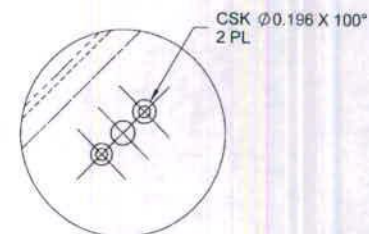
D3705-3F COVER PLATE FLAT PATTERN



**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



**DETAIL E
SCALE 4X
4 PL**



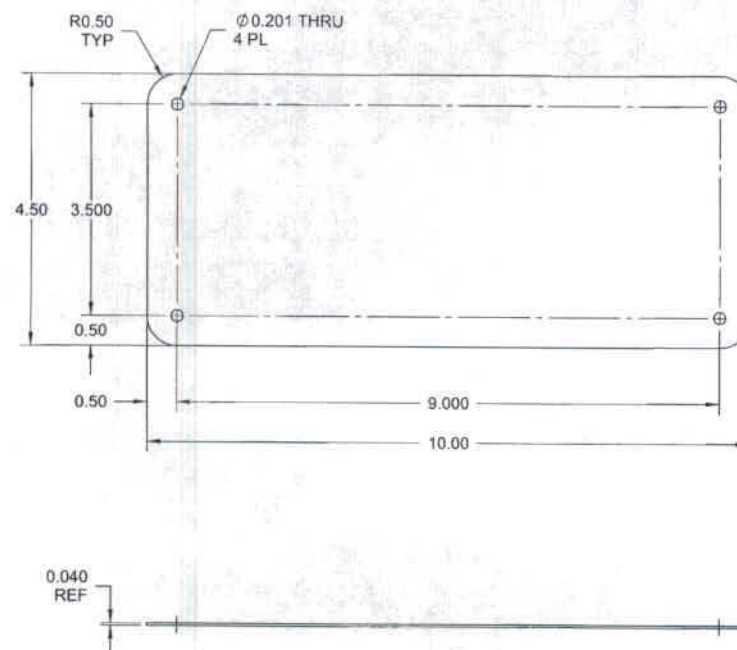
**DETAIL F
SCALE 4X
4 PL**

RELEASED
09/22/05

D3705-3/-3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.77 lbs

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D3705-5 ACCESS PANEL

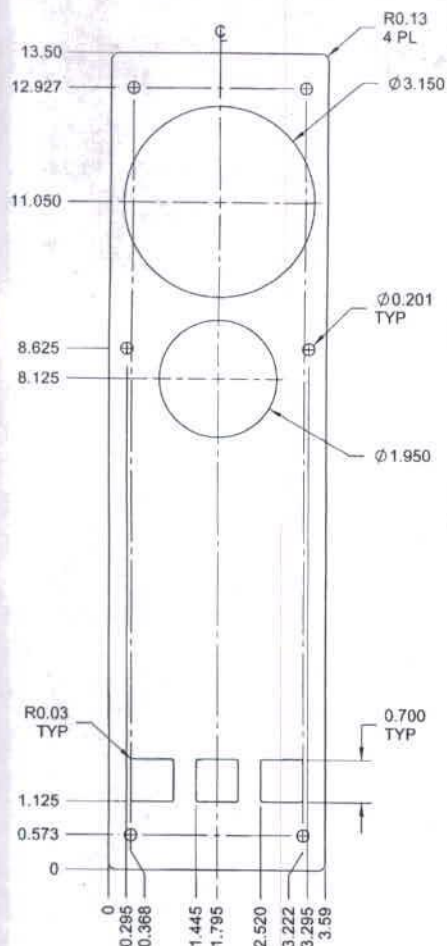
D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

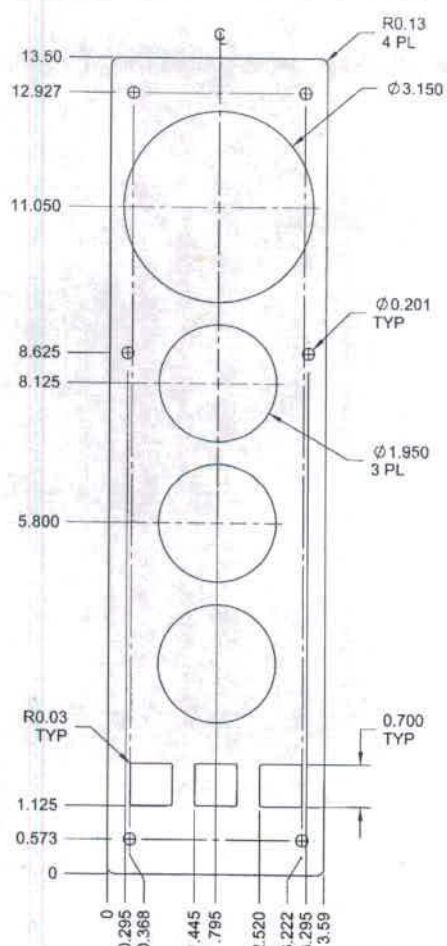
who says

RELEASED
3/2/05

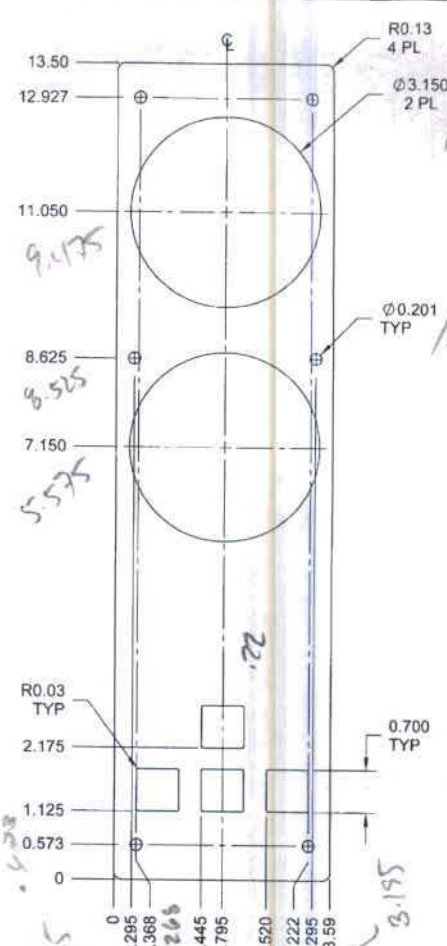
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D3705-7 FACE PLATE



D3705-9 FACE PLATE



D3705-11 FACE PLATE

**SIDE VIEW
TYP**

RELEASED
10/02/05

D3705-7/-9/-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-X" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

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MFG. APPR.		D3705	SHEET 6 OF 6
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